

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

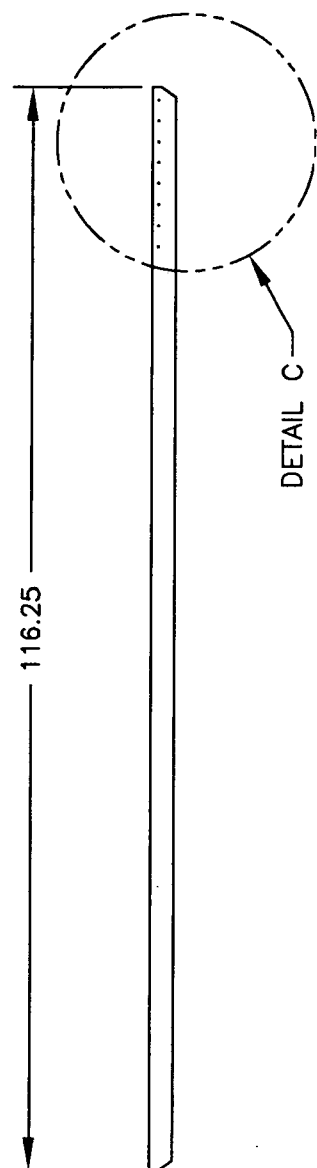
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

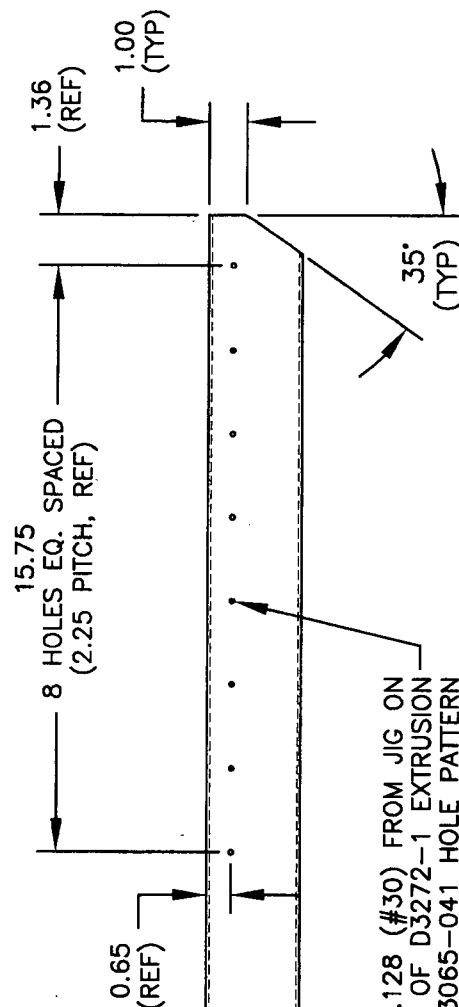


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

21609/13



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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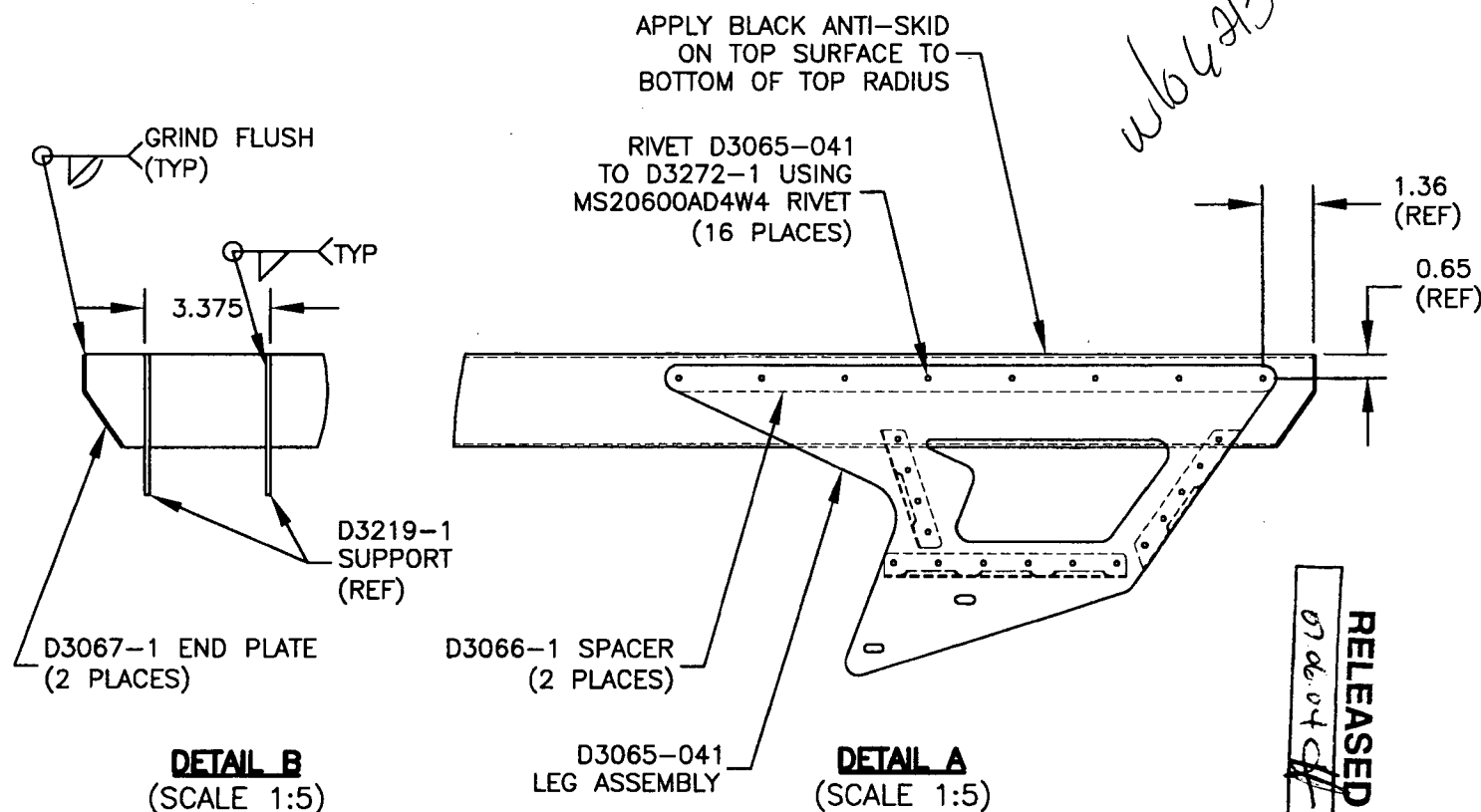
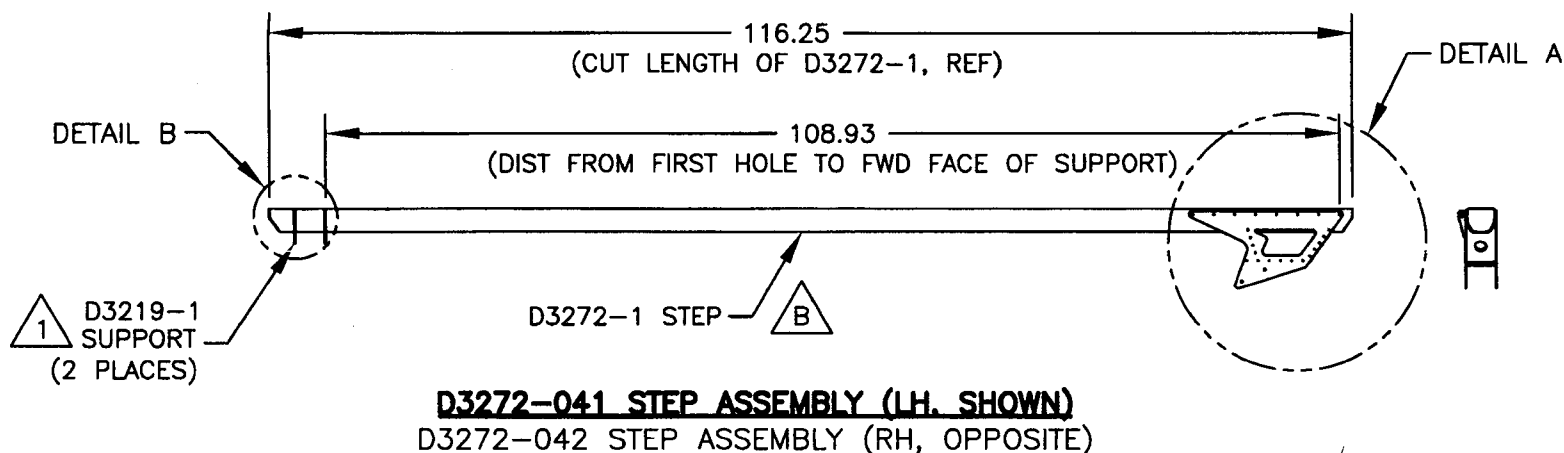
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DESIGN	q	DRAWN BY	J	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CE	HAMKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



RELEASED
07.06.04

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04***B**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOWN COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *62132*
B/10-8-16

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Picklist Print

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Page 6

Work Order ID: 62132

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010

Required Date: 9/28/2010

Start Qty: 5.00

Required Qty: 5.00

MS21042L4
Nut

Purchased

No

250

Each

5,136.000

8 ✓ 40



10/14/10 SP

Location

Loc Qty

Loc Code

ST300

5136

113422

68

114523

28

114718

16

114784

104

115108 ✓

1920

115589

1900

115621

1100

40

MS21042L5
Nut

Purchased

No

250

Each

1,069.000

2 ✓ 10



10/14/10 SP

Location

Loc Qty

Loc Code

ST139

69

114813

69

ST300

1000

115156 ✓

500

115594

500

10

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Page 5

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Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010

Required Date: 9/28/2010

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

307.4060

Abraison Strip

*cut (2) D2856-400-720
per dwg (per kit)*

Location

Loc Qty

Loc Code

ST403

307.4060421

91.4060421

216

250 Each

97.0000

2

*8x 48
2x 10
10/16/145*

D3235-1

Manufactured No

Mounting Lug

Location

Loc Qty

Loc Code

ST471

97

60195

17

60450

40

60851

40

250 Each

77.0000

1

*5
10/16/145*

D3278-041

Manufactured No

Support Assembly

Location

Loc Qty

Loc Code

ST471

77

60201

37

61212

40

250 Each

2,036.000

2

*5
10
10/16/145*

MS21042L3

Purchased No

Nut

Location

Loc Qty

Loc Code

ST300

2036

114523

109

114784

1927

10

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Page 5

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Page 4

Work Order ID: 62132

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010

Required Date: 9/28/2010

Start Qty: 5.00

Required Qty: 5.00

AN960JD416 NAS1149D0463J Purchased No

250

Each

0.0000

16 80

Washer

AN960JD516 NAS1149D0563J Purchased No

250

Each

34.0000

4 20

Washer

Location

Loc Qty

Loc Code

ST 34
103694 18
107534 12
109287 4

D2230-3 Manufactured No

250

Each

150.0000

4 20

Lug

Location

Loc Qty

Loc Code

ST176 45
61198 45
ST476 105
55452 2
60191 3
60846 100

D2618 Manufactured No

250

Each

123.0000

2 10

Bushing

Location

Loc Qty

Loc Code

ST019 121
60193 7
60772 114
ST020 2
56892 1
57829 1

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Page 3

Work Order ID: 62132

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010

Required Date: 9/28/2010

Start Qty: 5.00

Required Qty: 5.00

AN3-35A



Bolt

Purchased

No

250

Each

130.0000



2

10

10/10/14 SP

Location

Loc Qty

Loc Code

ST353

130

115108

80

115457

50

AN4-13A



Bolt

Purchased

No

250

Each

644.0000



8

40

10/10/14 SP

Location

Loc Qty

Loc Code

ST357

144

115108

144

ST358

500

115159

500

AN5-36A



Bolt

Purchased

No

250

Each

137.0000



2

10

10/10/14 SP

Location

Loc Qty

Loc Code

ST341

137

114292

5

114941

132

AN960JD10



Washer

NAS1149D0363J

Purchased

No

250

Each

16.0000



4

20

M45622 10/10/14 SP (38)

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

10

105792

10

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Work Order ID: 62132

Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010



Required Date: 9/28/2010

Start Qty: 5.00



Required Qty: 5.00

D3066-1 Manufactured No 180 Each 86.0000 2 10
 Spacer
 10-10-06



Location	Loc Qty	Loc Code
WA	86	
58540	3	
<u>60194</u>	35	<u>10</u>
61205	48	

D3067-1 Manufactured No 180 Each 72.0000 1 5
 End Plate
 10-10-06

Location	Loc Qty	Loc Code
WA	72	<u>5</u>
<u>60141</u>	72	

D3219-1 Manufactured No 180 Each 141.0000 2 10
 Plate
 10-09-23

Location	Loc Qty	Loc Code
WA	141	
<u>60859</u>	27	<u>7</u>
<u>61204</u>	114	<u>3</u>

MS20600-AD4W4 Purchased No 180 Each 1,699.000 16 80
 Rivets
 10-10-06

Location	Loc Qty	Loc Code
ST321	1699	
113368	62	
114181	11	
114718	2	
<u>115573</u>	624	<u>80</u>
115640	1000	

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Page 1

Work Order ID: 62132

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 9/16/2010

Required Date: 9/28/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1 End Plate		Manufactured	No			110	Each	72.0000	1	5		10.09.23	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				72					
				60141				72		5			
D3272-1 Step		Manufactured	No			110	Each	0.0000	1	5		10.09.22	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				10		5			
D3065-041 Step Leg Assembly Hi		Manufactured	No			180	Each	43.0000	1	5		10.09.06	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				43		5			
				60200				14					
				61216				29					

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Work Order ID 62132

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18 *[Signature]*

10-10-15

(5)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 62132

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Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u> </u>								

5
-Steps I did: Kits bagged & separated
& placed with steps
C. 10/10/10 (5)

W/O:		WORK ORDER CHANGES					
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Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:00

OVEN TEMPERATURE: 320°

FINISH TIME: 2:30

10-10-12

5 RH

230

Wing Walk as per dwg QSI005 4.4 Batch M115828

0.00



HandFinish

Memo

0.00

Hand Finishing

10/10/12

5 RH

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 RH

10/10/15

W/O:		WORK ORDER CHANGES					
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Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC Memo

0.00

Quality Control

5 10.05

200 QC5- Inspect part completeness to step on W/O

0.00



QC Memo

0.00

Quality Control

8/10/10/06

45 RH

210 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish Memo

0.00

Hand Finishing

BR 10-10-7.

5 RH

W/O:		WORK ORDER CHANGES					
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Item ID:	D350-591-312	Accept		Setup	Start	
Revision ID:						
Item Name:	Heli-Access-Step, Long RH				Stop	
Start Date:	9/16/2010	Start Qty:	5.00		Cust Item ID:	
Required Date:	9/28/2010	Req'd Qty:	5.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>5X</u>	<u>0</u>		
			⇒ m.d 12/14/06						
180  Large Fab Large Fab	Large Fab Memo	0.00 0.00				<u>5</u>	<u>0</u>		
	1-Assemble Leg Assembly as per Dwg D3272.		K 10.10.04						
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R <input type="checkbox"/> Aluminum Rod <input type="checkbox"/> <u>1118360</u> <u>M108436</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62132



Page 2

Thursday, September 16, 2010 12:49:28 PM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 9/16/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

⑤ 10.09.23

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/02/24



140

Chemical Conversion Coat per QSI005 4.1

0.00



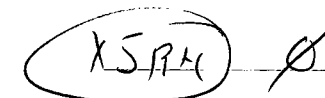
HandFinish

Memo

0.00

Hand Finishing

⇒ 10/09/30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62132



Page 1

Thursday, September 16, 2010 12:49:28 PM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 9/16/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-9-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Eurocap 704A 41640 011
F

HJH BG 10-10-14

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

m114877
m112860

3-Grind End Plate flush

10-09-23 *5* *φ*